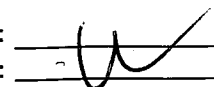
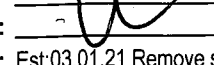


Date: Thursday, 31/07/2008 12:18:05 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : END PLATE
<b>Job Number</b> : 40851	
<b>Estimate Number</b> : 10547	
<b>P.O. Number</b> :	<b>Part Number</b> : D30671
<b>This Issue</b> : 31/07/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3067 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 38926	<b>Material</b> :
<b>Written By</b> : 	<b>Due Date</b> : 11/08/2008 <b>Qty:</b> 100 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est:03.01.21 Remove step 6 (Deburr) KJ Est Rev:B Now on Water jet 06-06-16 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S063	5052-H32 .063 Sheet
-----	--------------	---------------------



11.2



**Comment:** Qty.: 0.0656 sf(s)/Unit Total : 6.5625 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 (QQ-A-250/8)

M5052H32S.063) or6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)

Batch:

100947

B 8-8-8

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



PD

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3067

Dwg Rev: A

Prog Rev: A

B 8-8-8

2-Deburr if necessary

08/08/13 166 hm

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 8-8-8

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



counted

**Comment:** SECOND CHECK

08/08/13 166

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

Bend as per Dwg D3067

SB 28/08/25

166

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3067-1 PAR #: N/A Fault Category: Red / P.B. Pass' make NCR: Yes No DQA: D Date: 08/08/27  
 QA: N/C Closed: D Date: 08/08/27

NCR: <u>40851</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/27	# 20	all 166 parts were made of 0.080" thick mat instead of 0.063". R.C. operator pulled wrong mat. and was also missed during inspection	<u>PH</u> 08.08.27 <u>QSI</u> 042	Cosmetic change, no structural impact  ACCEPTABLE DEVIATION	<u>PH</u> 08-08-27	<u>S</u> 08/08/27	<u>PH</u> 08-08-27 <u>QSI</u> 042	<u>S</u> 08/08/27
								<u>S</u> 08/08/27

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 12:18:05 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 40851

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO NEXT STEP

*counted*  
*See 08/08/26 #166*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *62*

*8/8/27*

*166x*  
*See*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/08/27*

Job Completion



*u 08/08/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

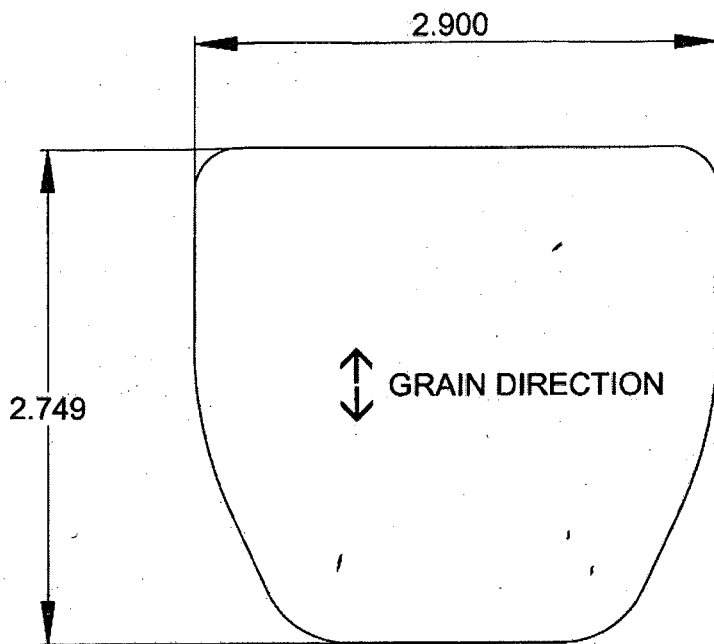
**NOTE:** Date & initial all entries



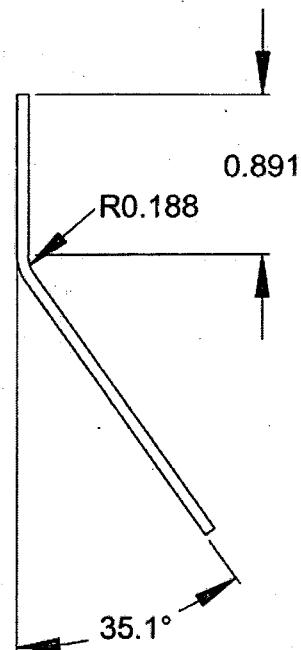


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>UP</i>	DRAWING NO. <b>D3067</b>	REV. A SHEET 1 OF 1
DATE <b>02.09.11</b>		TITLE <b>END PLATE</b>	SCALE 1:1
A	02.09.11	NEW ISSUE	

**RELEASED**  
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

**D3067-1 END PLATE**

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063) OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063) ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
NO. 40851

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